

Date: Monday, 8/21/2006 2:11:14 PM
 User: Kim Johnston

Process Sheet

~~SLIP~~ SLIP

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 28250	Part Number	: D2649
Estimate Number	: 11010	Drawing Number	: D2649 REV B1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 8/21/2006 S.O. No. : N/A	Drawing Revision	: B1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 9/5/2006 Qty: 1,000 Um: Each
Previous Run	: 25864		
Written By	:		
Checked & Approved By	: <u>SG 06 08.21</u>		
Comment	: Est F 02.03.26 Added turning on Cobra NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W 19051x80' 358 100704 180' +155
		Comment: Qty.: 0.2975 f(s)/Unit Total : 297.4650 f(s) 6061-T6 Tube .375 x.058W Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall Batch _____ <u>Reut/3/15 - 150</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL <u>PG</u> <u>Issue P.O</u> Turn per drawing D2649 Rev B1 Comment: HARDINGE CNC LATHE SMALL Machine as per folio on cobra machine.
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>PG</u> <u>Receive & Inspect</u> for transit damage <u>06/09/18</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC5	SECOND CHECK Comment: SECOND CHECK <u>Inspect Level 5</u> , MS, <u>06/09/18</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>LG</u> <u>BF 06-09-18</u>
6.0	DC	DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 <u>act 09/19</u> <u>W 06-09-18</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28250
Description: Crossbolt Spacer	Part Number:	D2649
Inspection Dwg: D2649 Rev: B1		Page 1 of 1

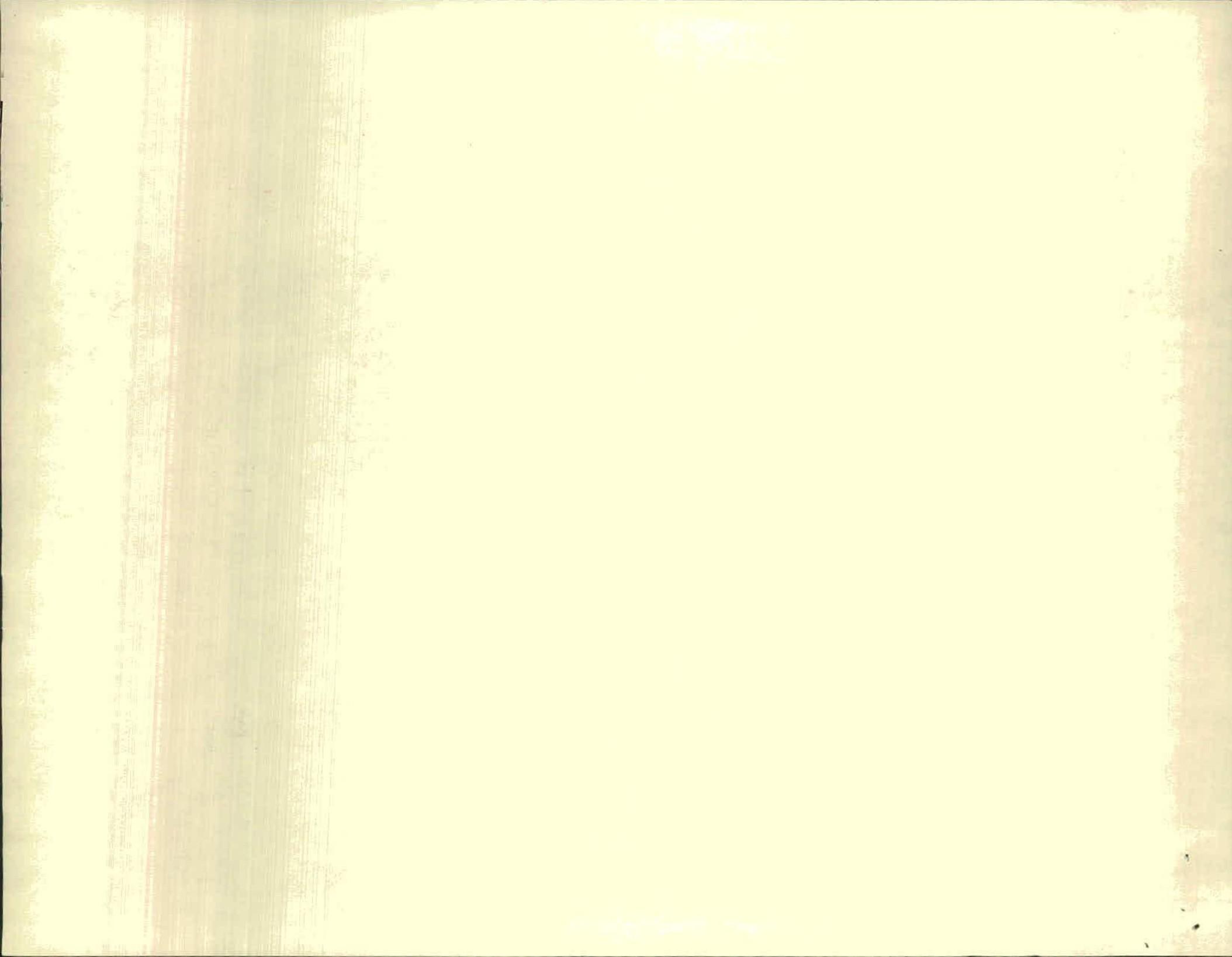
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Note: machined by METEC !!

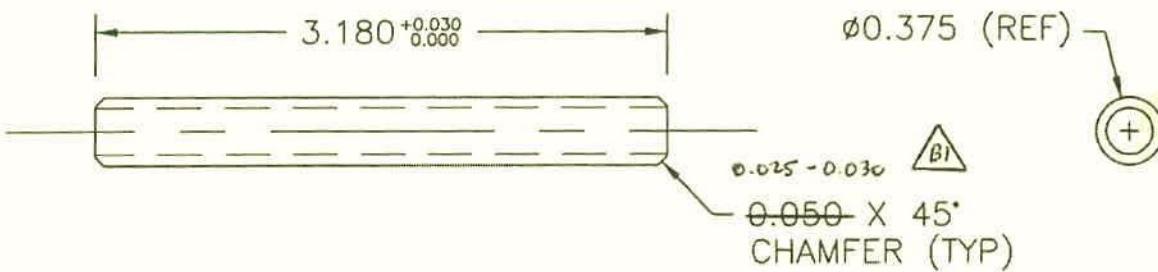
Measured by:	<u>MJS</u>	Audited by:	<u>MJS</u>	Prototype Approval:	N/A
Date:	<u>06/09/18</u>	Date:	<u>06/09/18</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	FF



DART

DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	OP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

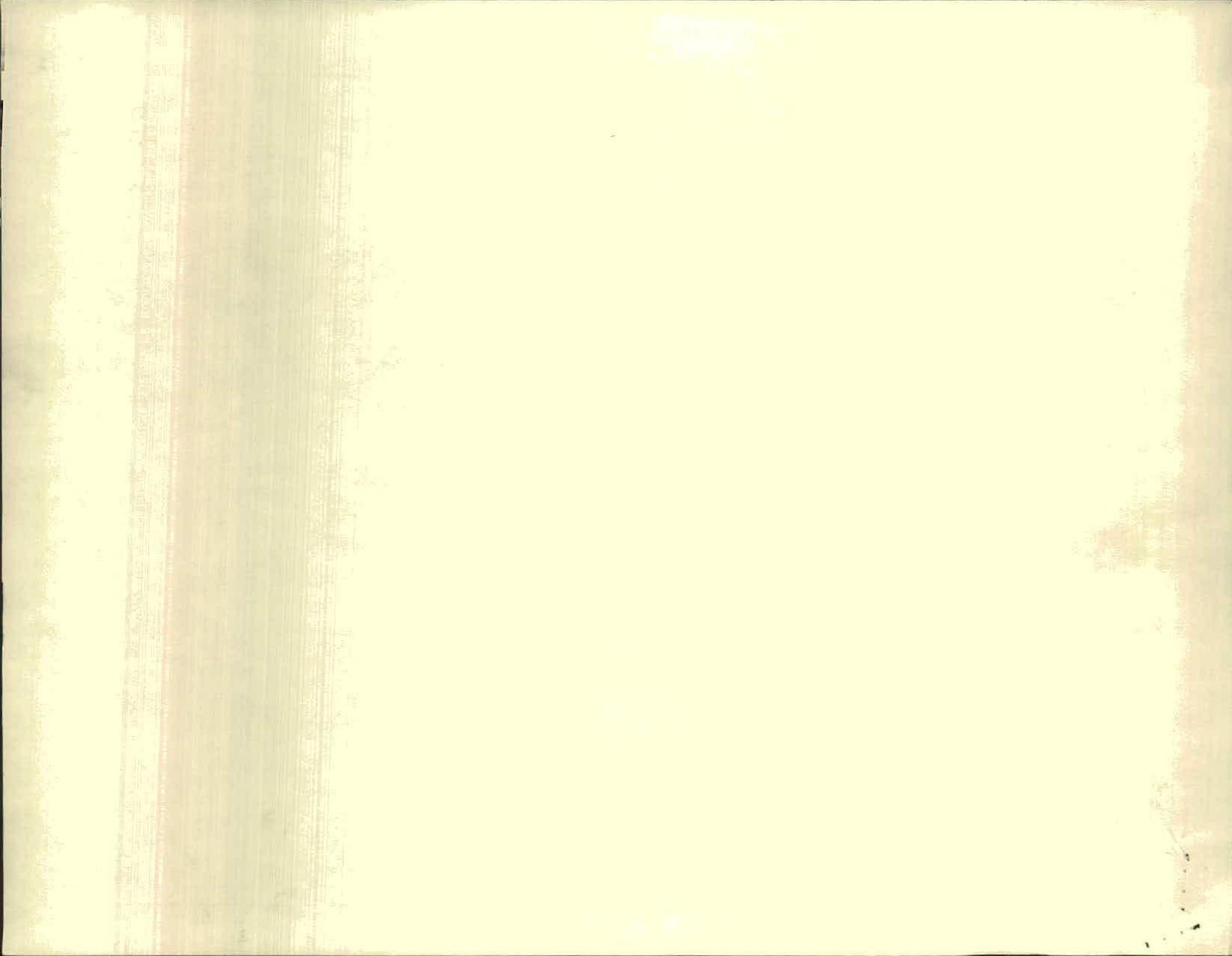
RELEASED
 98.01.20 DS


MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-~~700/4~~)
 0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO
STORING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28250





CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	MATERIAL BATCH NUMBER	P.O. NUMBER
358	D2649	Cross Bolt Spacer	M100704	Linda
155	D2649	Cross Bolt Spacer	M19051	Linda
606	D2651-1	Plug	M101421	Linda
200 ✓	D2743	Cross Bolt Spacer	M100451	Linda

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz". Below the signature, the name "Shigi (Regula) Walz" is printed in a smaller, sans-serif font.

Vankleek Hill, September 15, 2006

